

Work Order ID 65148

Thursday, January 06, 2011 3:31:12 PM



Page 1

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 1/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: PA

Date: 1-10-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3571	Rev A

100
 BAND SAW
 Bandsaw
 Jeaspa Bandsaw
 Memo
 Cut blank 2.90 " long
 0.00
 0.00
 11/01/11
 6 0

110
 HAAS CNC VERTICAL MACHINING #1
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A □2-Debur
 per dwg D3571
 0.00
 0.00
 10/00/11
 6 0

120
 QC2- Inspect parts off machine FAI/FAIB
 QC
 Quality Control
 Memo
 0.00
 0.00
 11/01/11
 6 0

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Thursday, January 06, 2011 3:31:12 PM



Page 3

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 1/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 11/01/14

170

Identify as per dwg & Stock Location: *change* 245

0.00



Packaging

Memo

0.00

Packaging

11/14 @ SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/17
MF
11-01-17

Picklist Print

Thursday, January 06, 2011 3:31:16 PM

Page 1

Work Order ID: 65148

Parent Item: D3571-1

Parent Item Name: Guide



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	25.9944	0.241	1.522105			



6061-T6 Bar .750 X 1.50



Location

Loc Qty

Loc Code

MAT

25.9944

116405

25.9944

1.522 and 11/01/11

DART AEROSPACE LTD		Work Order: 651416
Description: Guide		Part Number: D3571-1
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	—		Vern	ML-7
Ø1.00 Depth 100	+/-0.010	Ø.999 X .100	—		"	"
2.75	+/-0.030	2.752	—		"	"
1.38	+/-0.030	1.375	—		"	"
1.25	+/-0.030	1.248	—		"	"
0.63	+/-0.010	.624	—		"	"
0.031 chamfer	+/-0.010	.025	—		"	"
Ø0.500	+0.006/-0.001	Ø.503	—		"	"
Ø0.201	+0.005/-0.001	Ø.203	—		"	"
R0.25	+/-0.030	R.250	—		Rad gage	REF
0.260	+0.000/-0.010	.253	—		Vern	ML-7
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.388 X 100°	—		"	"
0.125	+/-0.010	.125	—		"	"
2.250	+/-0.010	2.243	—		"	"
0.250	+/-0.010	.254	—		"	"
0.188	+/-0.010	.189	—		"	"
0.063 chamfer	+/-0.010	.065	—		"	"

Measured by: [Signature]
Date: 11/01/11

Audited by: [Signature]
Date: 11/11/12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

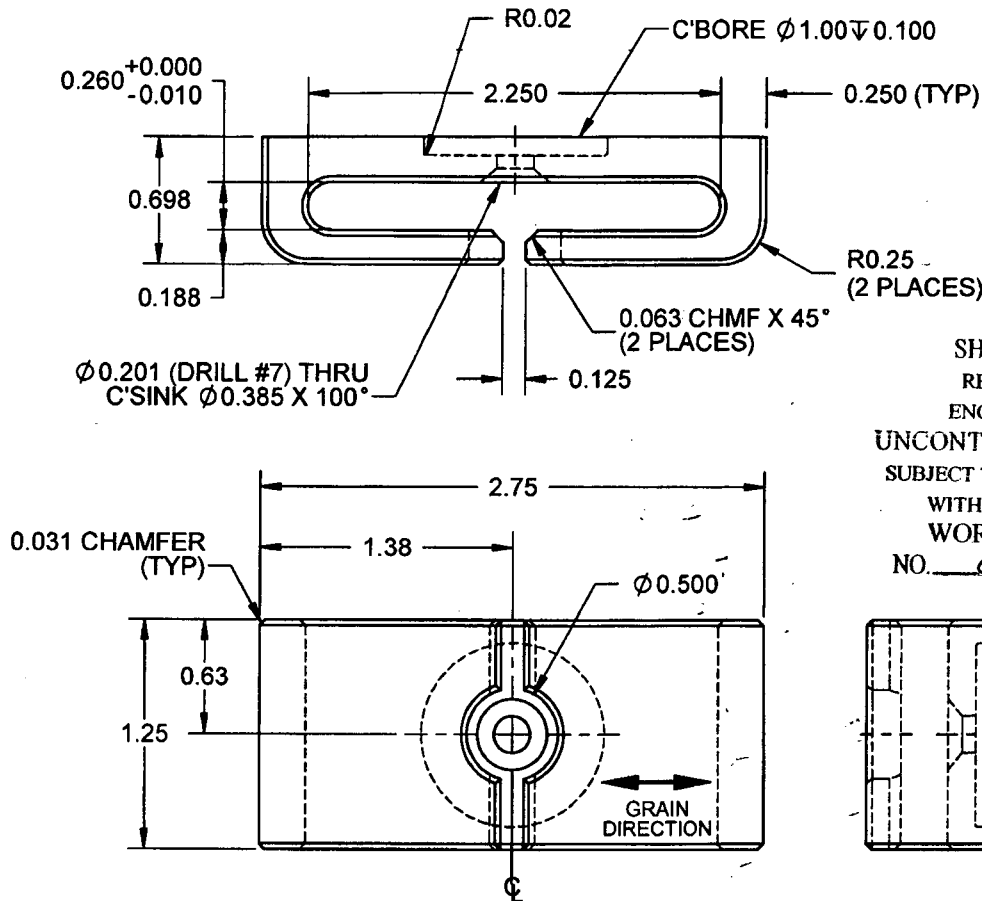
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

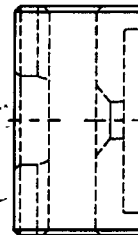
NOTE: Date & initial all entries

DART

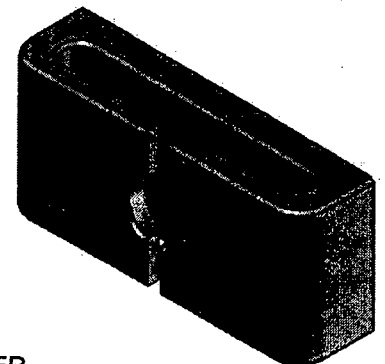
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE SCALE 1:1		
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]*

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *05145*

2/11-01-7**D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT CL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

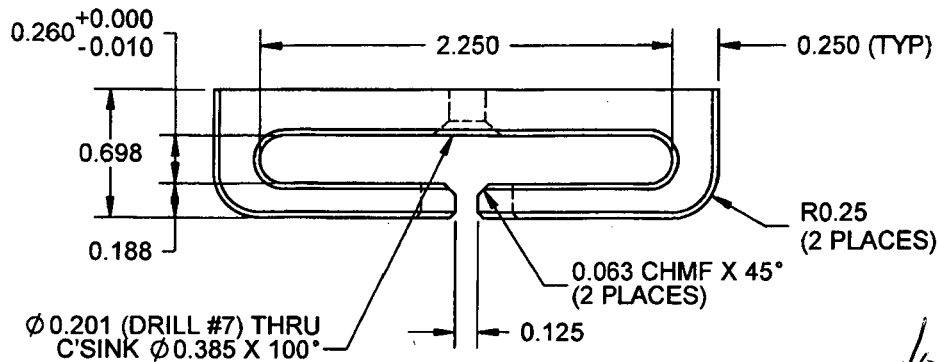
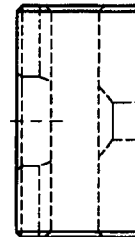
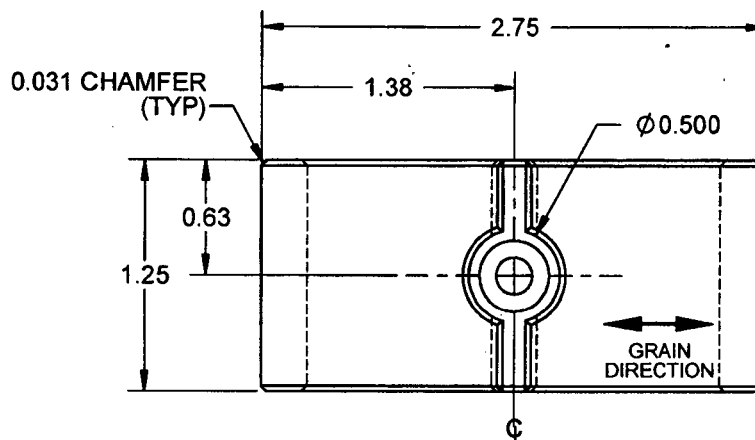
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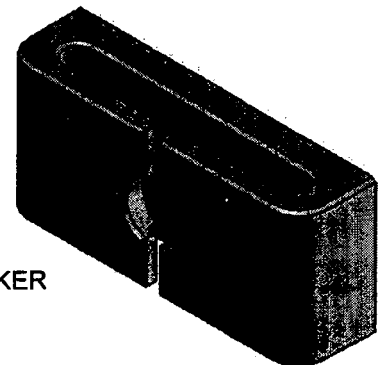
NOTE: Date & initial all entries

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CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3571	REV. A
DATE 07.01.29	TITLE GUIDE	SHEET 2 OF 2 SCALE 1:1	

RELEASED07.04.12 *PH**w/o 45146***D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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